

November-27-14 7:55:36 AM

**\*126842\***

Page 1

**DAS**  
**23**  
**9-89**

14-11-27

**DAS**  
**23**  
**9-89**

14-11-2

# Work Order ID 126842

**\*126842\***

Page 2

November-27-14 7:55:36 AM

Item ID: D3942-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Angle  
 Start Date: 11/27/14 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 11/28/14 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(40)			DAS 38 9-89
<b>*120*</b>									
QC	Memo	0.00							

Quality Control

NOV 28 2014

130		0.00			DAS 30 9-89	40			
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	1- Bend as per dwg D3942								

11/28/14

140	QC5- Inspect part completeness to step on W/O	0.00				(40)			DAS 38 9-89
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

NOV 28 2014

**Work Order ID 126842****\*126842\***

Page 3

November-27-14 7:55:36 AM

Item ID: D3942-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Angle  
Start Date: 11/27/14 Start Qty: 40.00 **\*40\*** Cust Item ID:  
Required Date: 11/28/14 Req'd Qty: 40.00 **\*40\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location. <u>OK</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00				40			
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

NOV 28 2014

ML5 14-11-28

AA 14-11-28

# Picklist Print

November-27-14 7:55:35 AM

Page 1

Work Order ID: 126842

**\*126842\***

Parent Item: D3942-1

**\*D3942-1\***

Parent Item Name: Angle

Start Date: 11/27/14

Required Date: 11/28/14

Start Qty: 40.00

Required Qty: 40.00

Comments: Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased	No			100	sf	586.3388	0.015	1			DAS
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**\*M304S18GA\***

304/316 .050 Sheet

**\*\***

**23**  
**9-89**

14-11-27

Location

Loc Qty

Loc Code

MAT020

586.33876

117188

3

117766

5

120604

5

122325

3

123155

3

124572

35.73

125552

1.1155

M126098

7.6042

M126647

31.55

M128254

34.746

M128435

35.45

M128864

11.98206

M129530

49.6185

M130345

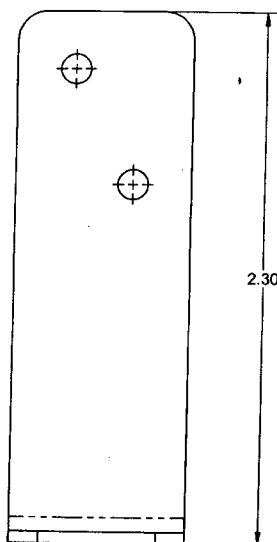
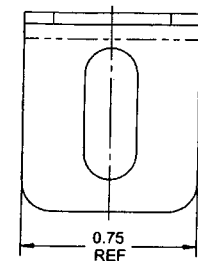
103.5425

M130923

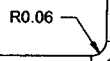
256

129530

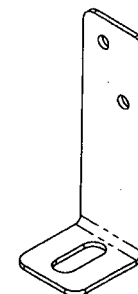
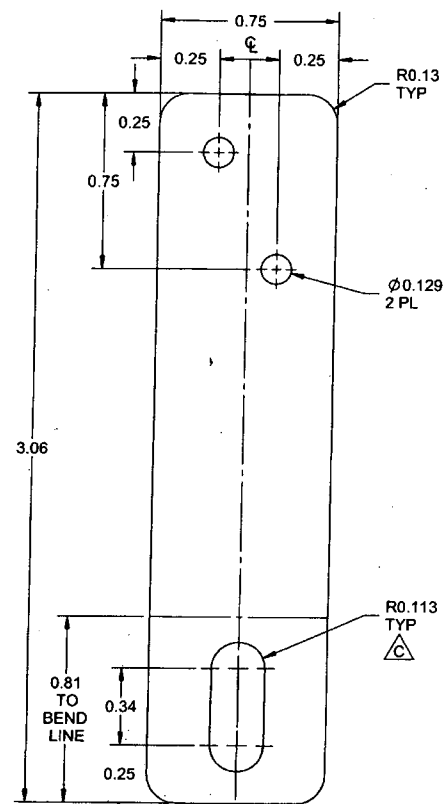




0.050  
REF



**D3942-1 ANGLE**  
MADE FROM D3942-1F



**D3942-1F FLAT PATTERN**

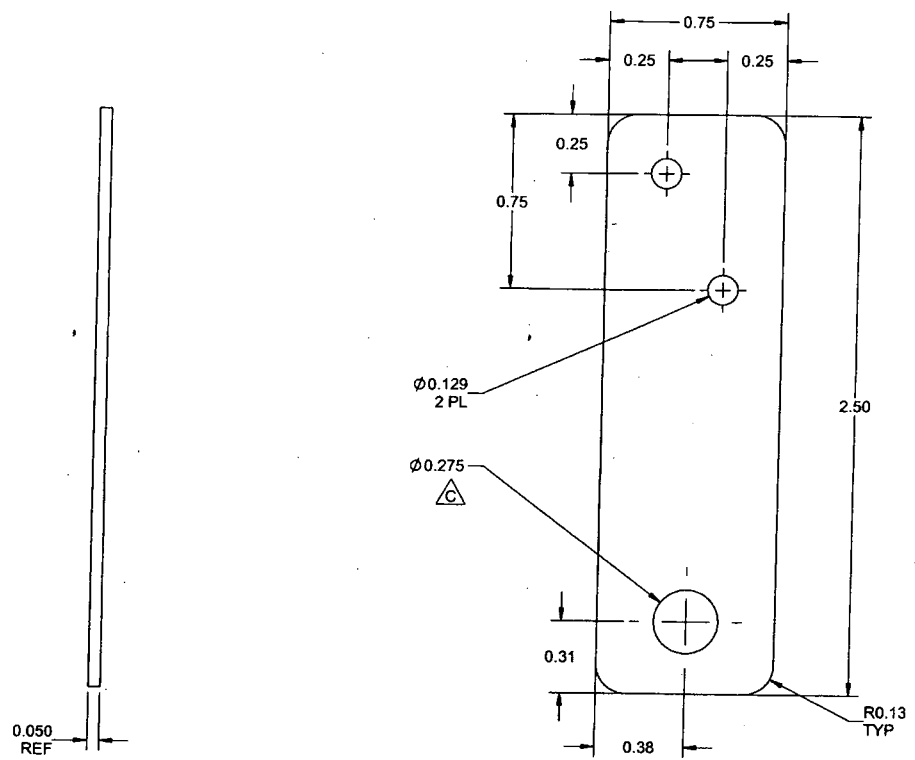
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 LBS

*WLO 126042*

**RELEASED**  
2011-12-12

C	INCREASE SLOT/HOLE SIZE TO ALLOW PROPER FITTING OF PANEL - 0.113 WAS 0.094, ZN B2-1; 0.275 WAS 0.257, ZN C5-2 (REF PAR 10-008)	XDF	11.09.02
B	REVISE LENGTH OF -3 PART, ZN C3-2; UPDATE IDENTIFICATION, ZN A7-1, A7-2	HS	10.11.19
A	NEW ISSUE	HS	09.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.02		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DART AEROSPACE LTD D3942 DRAWING NO. REV. C SHEET 1 OF 2 TITLE BRACKET SCALE NTS. <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			






**D3942-3 CLIP**

**RELEASED**  
2011-12-12

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 0.03 lbs

DESIGN			<b>DART AEROSPACE LTD</b>	
DRAWN	XDF		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3942	SHEET 2 OF 2
APPROVED			TITLE	SCALE
DE APPR.			BRACKET	NTS
DATE	11.09.02		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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